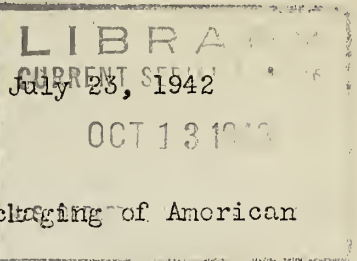


Historic, Archive Document

Do not assume content reflects current
scientific knowledge, policies, or practices.

1.9422
D8C41
Cap. 6 ✓

UNITED STATES DEPARTMENT OF AGRICULTURE
Agricultural Marketing Administration
Washington, D. C.



CHEESE GRADERS' MEMORANDUM NO. 8

To: All Cheese Graders and Supervisors of Processing and Packaging of American Cheddar Cheese

From: Rob R. Slocum, Senior Marketing Specialist, Dairy and Poultry Branch - AMA

Subject: Procedure to be Followed in Grading the Natural Cheese and in Supervising the Processing, Packaging, Grading and Weighing of American Cheddar Processed Cheese under Announcement FSC-769.

Announcement FSC-769, dated July 8, 1942, covers American cheddar processed cheese to be purchased by the Agricultural Marketing Administration through the Federal Surplus Commodities Corporation. Careful attention should be given to the following points contained in this announcement:

QUALITY: The product shall be process cheese prepared in accordance with best commercial practice under strictly sanitary conditions and shall be free from impurities. It shall be prepared by comminuting and mixing one or more lots of cheese into a homogeneous plastic mixture by the action of heat, with or without the incorporation of not more than three percent of a suitable emulsifying agent. It shall be made from a blend of natural American cheese, of which at least fifty percent shall meet the quality requirements for No. 1 cheese and the remainder the requirements for No. 2 cheese, both as specified below. At least forty percent of the No. 1 cheese used in the blend shall be cheese not less than six months old and none of the cheese used shall be less than ten days old at the time of grading.

You should carefully note the quality requirements for No. 1 and No. 2 American cheddar cheese. The specifications for the quality requirements for No. 1 cheese are identical with those for U. S. No. 1 with the exception of the finish and appearance. No. 1 American cheddar cheese permits slightly more irregularity in shape and permits slight defects in bandaging and paraffining, but shall be reasonably free from surface mold and free from interior mold and from soft or rot spots in the rind.

The quality requirements for No. 2 American cheddar cheese are slightly less stringent than the requirements for U. S. No. 2A cheese. In addition to the defects permitted in U. S. No. 2A (see FSC-758), No. 2 cheese as specified in this announcement permits slightly fruity, slightly whey taint, slightly metallic and slightly yeasty flavors, an open body or one that is slightly crumbly and with numerous sweet holes, numerous mechanical openings and an acid-cut color defect. The remainder of the specifications for No. 2 are identical with those required for U. S. No. 2A.

Particular notice should be given to the fact that the finished processed product shall contain not more than thirty-nine percent of moisture or one percent below the Federal Standards for Process Cheese and not less than fifty percent of milk fat on a water-free basis. Also, the processed product shall be free of mold, the body shall be smooth, medium firm and resilient with practically no openings or pinholes. The texture shall be close and free of lumps or graininess and show not more than slight brittleness,

show a free slice and shall not stick to the knife or break when cutting.

The finished product shall be colored a medium color and the flavor must be clean and characteristic of mild to medium cured natural American cheese. The product shall be guaranteed to keep in tropical climates for a period of six months if held under proper conditions but without refrigeration.

INSPECTION: The natural cheese and the process cheese shall be subject to inspection by representatives of the Agricultural Marketing Administration. The quality of the natural cheese, and the quality and weight of the process cheese shall be evidenced by certificates issued by the Agricultural Marketing Administration. All inspection fees and charges shall be paid by the vendor.

A regular cheese grading certificate shall be issued by the person who grades the natural cheese and it should cover each vat of cheese graded. Each package of cheese inspected shall be stamped with a U.S.D.A. lot number for identification.

Regular grading fees should be charged and collected from the contractor or from the person who sells the natural cheese to the contractor for the grading service performed. A statement should be placed on each such cheese grading certificate under "remarks" as follows: "The accepted cheese covered by this certificate is to be used by the _____ (name of contractor) in the preparation of American cheddar process cheese purchased by the Federal Surplus Commodities Corporation." The grader should record his grading results on a regular cheese grader's memorandum and a copy of this should be used in checking against the cheese used for processing.

A cheese grading certificate must be issued covering each separate carlot of process cheese shipped from the processing plant. This certificate should show the vendor as the applicant and seller and the Federal Surplus Commodities Corporation as the buyer. The certificate should be dated whenever possible as of the day on which the shipment is made from the plant. Certificate should show the total number of cases of process cheese contained in the shipment and should also refer to the date on which this particular cheese was processed. This would mean that the process cheese of each day's production should be stacked and identified by the date of production until such time as it is shipped. In the body of the certificate, a statement to the following effect must be made: "The process cheese covered by this certificate was prepared under supervision of the Agricultural Marketing Administration from natural cheese which had been officially graded. This cheese was prepared under sanitary conditions and was found to conform to the requirements of Announcement FSC-769 under which it was purchased by the testing of samples taken at random from the processed cheese during its production. Test weights of sample cases of the product were made from time to time and the net weight was found to be O.K. Moisture and fat tests were made of composite samples sent to A.H.A. laboratory." (See paragraph five below.) If the test weights are equal to or higher than the marked weight, the test weight will be indicated as O.K. If the test weight showed a shortage, the amount of this shortage must be given and the contract net weight of the lot covered by the certificate must be determined on the basis of this shortage. In all cases, the certificate must carry a statement of the contract number under which the purchase was made as "Contract No. ____". On the certificates issued covering the finished product, there should be shown opposite the word "fees" the cash amounts for the day's operation. This would consist of a fee for the number of hours put in by the supervisor

on this operation at the plant at the rate of \$2.00 per hour. There should also be shown any amounts to be charged the contractor as travel expenses and/or as subsistence expenses. It is only necessary to enter the amounts for fees and expenses on one certificate issued each day. On any other certificates issued on the same day, the statement may be made opposite the words "fees and expenses", "included on certificate No. _____."

In addition to the services which are rendered by the supervisor of this operation in the processing plant as a grader of the natural cheese, the duties of such supervisor will be as follows:

1. He shall permit only such natural cheese to be used in processing the product as has been officially graded and passed as meeting the requirements as stated in Announcement FSC-769.
2. He shall see that the natural cheese used is blended as required in the announcement from the standpoint of age requirement and in the proper percentage as to grade.
3. He shall see that the cheese is processed and packed under strictly sanitary conditions.
4. He shall test weight at least five percent of the cases packed and shall keep an accurate record of the net weight of each lot weighed. To obtain the tare weight, he may weigh groups of cases complete with the correct number of cans and linings in lots of not more than ten cases. The weighing of individual cases and shipping cans with liners required to fill each case should be repeated from time to time in order to check and make sure that the correct average tare is being used. He shall select sample cases at random as packed from the delivery line. He may weigh the packed cases in groups of ten and after obtaining the average gross weight, he should then deduct the average tare weight as indicated above; this will give him the average net weight per case. Care must be taken to see that the test weights are made from time to time throughout the day in such a manner as to secure a representative sample of the lot. A detailed report should be made of these test weighings. Should the supervisor find any indication that the net weights are not correct, he should immediately notify the plant superintendent so that corrections may be made.
5. He shall take samples of the processed cheese for moisture and fat determination by the A.M.A. laboratory to which he sends them. One six or eight-ounce sample should be taken from every one hundred cases or of each one-hour production period, whichever is the most practicable. This sample shall be made up by compositing at thirty minute intervals. The composite samples thus obtained shall be numbered with a U.S.D.A. lot number covering shipment or carlot, together with sub-lot numbers for each one hundred cases or each one-hour production period. He shall see that

each carlot is properly identified according to U.S.D.A. and sub-lot numbers. The supervisor should also keep a constant check on the fat and moisture determination made by the plant laboratory, so that he may know of any adjustment needed in the operation.

6. Samples should be selected from each blended lot and should be graded and tested for quality to determine that the finished product meets the requirements as set forth in Announcement FSC-769.
7. The supervisor shall issue the necessary grading certificates in accordance with instructions previously given in this memorandum, covering shipment of finished product from the plant where the product is being prepared.

PACKING, PACKAGING AND MARKING: Note carefully the provisions in Announcement FSC-769 under this heading. The cans in which the process cheese is packed must be lacquered and parchment lined on the inside and shall bear labels that comply with the Federal Food, Drug and Cosmetic Act. The labels shall also indicate the description of the contents and name of the vendor and the net weight. The cans shall be packed in accordance with the Specifications for Canned Foods Cases as contained in Form FSC-1539-C. Each case shall be plainly marked with the phrase "American Cheddar Process Cheese", number of cans and net weight of can, name and address of vendor, FSC contract number, lot number and date processed.

DELIVERY: Note that the delivery period as specified under the announcement shall be not longer than twenty-five days and shall be not later than sixty days after date on which the offer is submitted. Delivery of the product will be taken by the F.S.C.C., on its option, during the delivery period specified in the offer.

Should graders or supervisors of processing be in any doubt as to their duties or the manner in which they should be performed, they should immediately get in touch with their supervisor or, if necessary, with this office.

Robt. R. Sloman